# 5 - Disassembly Instructions


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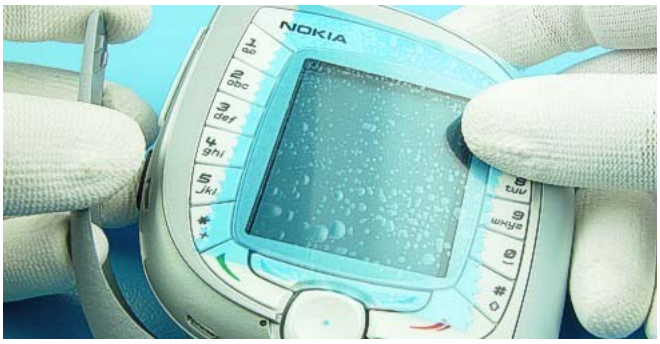
# Disassembly Instructions

1. First remove LH Sleeve.

1




2. Now remove RH Sleeve.

2

3. Dismount C-Cover.

3

4. Pull up D-cover, which is attached to B-cover with adhesive tape.

4

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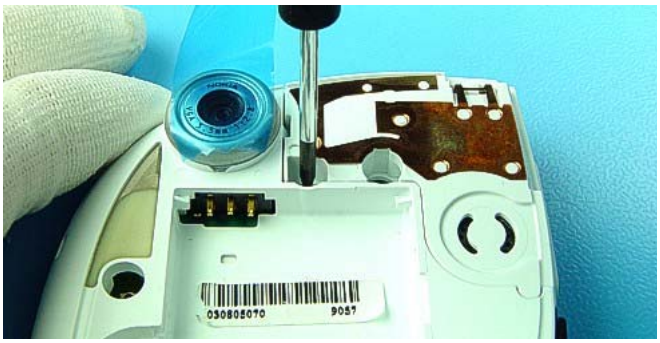
5. Unscrew Antenna screw. Use a new Torx Plus screw and a torque of 26 Ncm for assembly.

**5**



6. The Corner Piece fits very tight, so it needs some extra force to separate it from the B-cover with the SRT-6.

**6**

7. The A-cover is fixed with several plastic clips. Start with the clip near to the system connector.

**7**

8. Loosen the clips anti-clockwise by using the SRT-6 as a lever. Do not twist the SRT-6 because this could cause damage to the cover.

**8**

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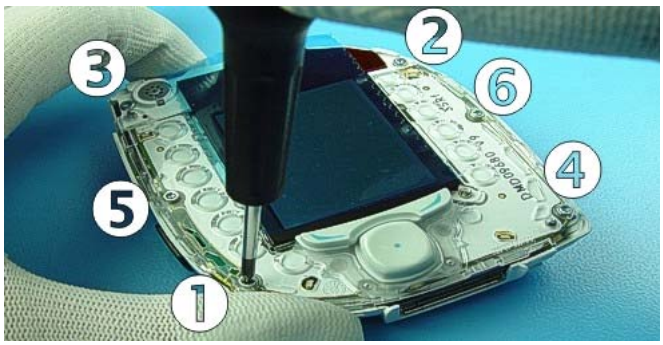
9. Remove A-cover.

**9**

10. Unscrew the six Torx Plus screws using the order shown. For assembly the reverse order and a torque of 19 Ncm has to be used for an old B-cover and 22 Ncm for a new B-cover. No electric or air driver are allowed to be used for assembly.

**10**

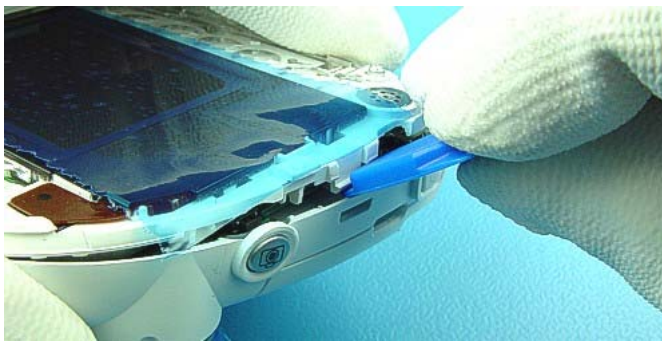



11. Unlock the three clips from the UI Assembly, as indicated.

**11**

12. If unlocking doesn't work check that the Antenna screw has been removed.

**12**

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13. Remove UI Assembly.

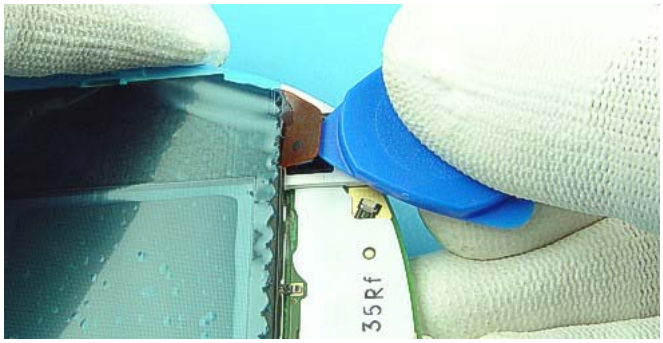
**13**

14. After opening the side clips the Lightguide can be removed.

**14**

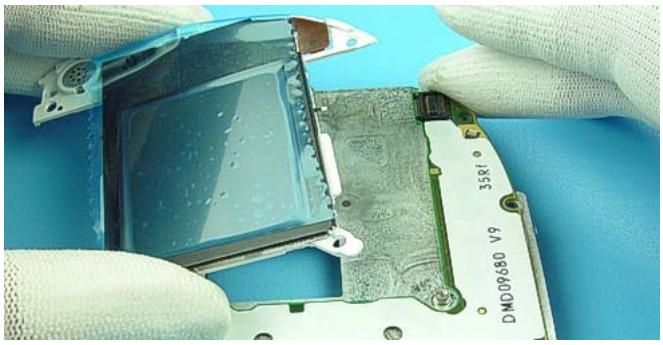
15. Carefully open LCD Connector with the SRT-6. Do not damage the sensitive flex foil.

**15**




16. Remove LCD.

**16**





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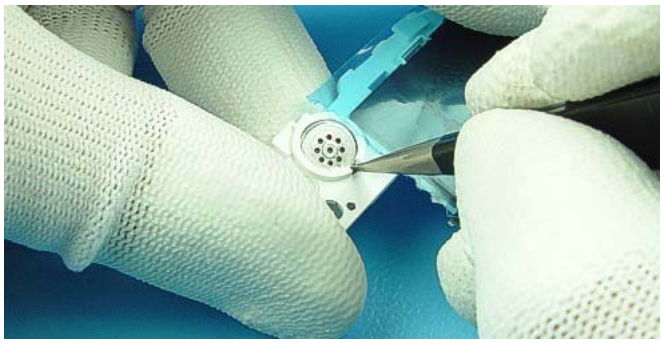
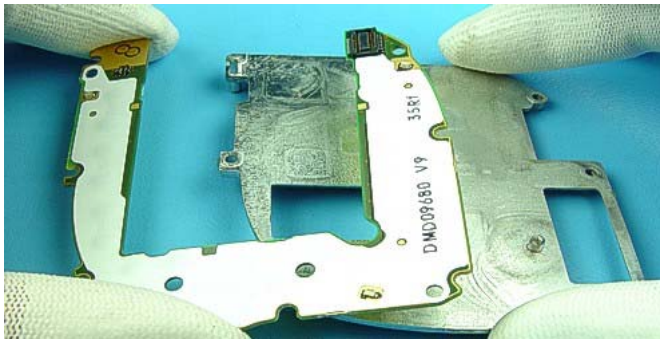
17. Press out Earpiece from guiding pin side.

**17**



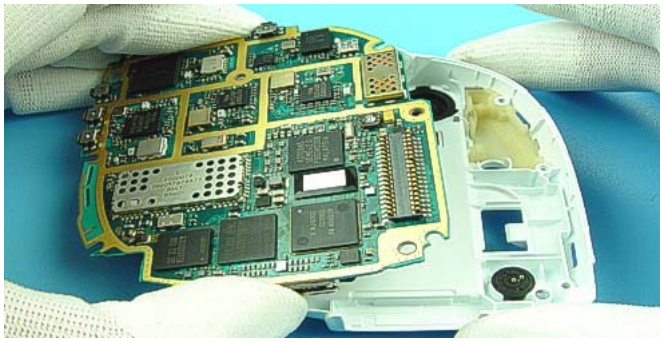
18. Separate UI PWB from Engine Shield.

**18**



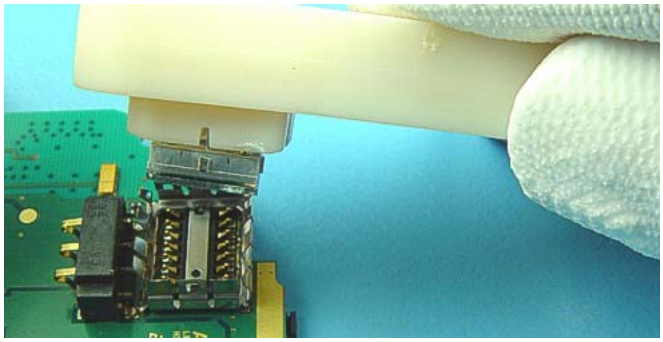

19. Dismount Engine module.

**19**



20. Use disassembly side of the SRT-11 to remove the VGA Camera. Use the other side of the SRT-11 for assembly.

**20**

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21. Lever out WCDMA Antenna from B-cover.

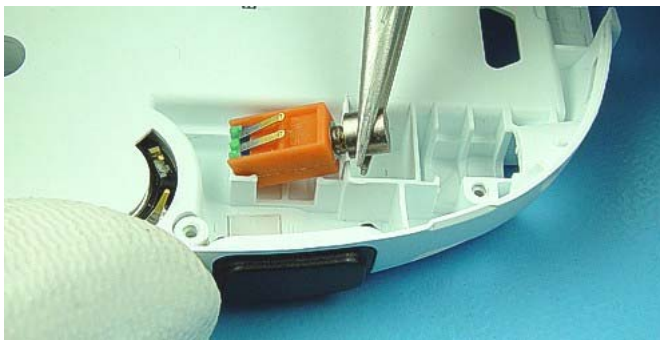
**21**

22. Using a charger plug remove the DC Jack.

**22**

23. Remove Vibra Motor, taking care not to damage the spring contacts.

**23**



24. Unlock the side snaps to remove the IT Window.

**24**

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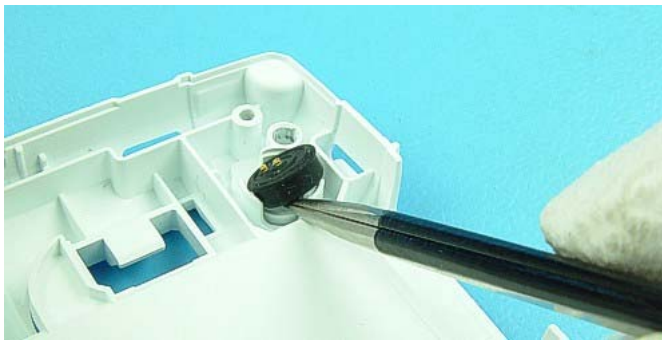
25. Push out the Volume Keys, taking care not to damage the silicon.

**25**

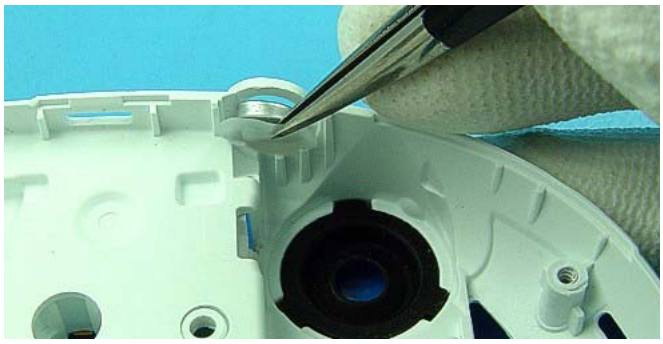
26. Remove the Microphone from its guidance.

**26**



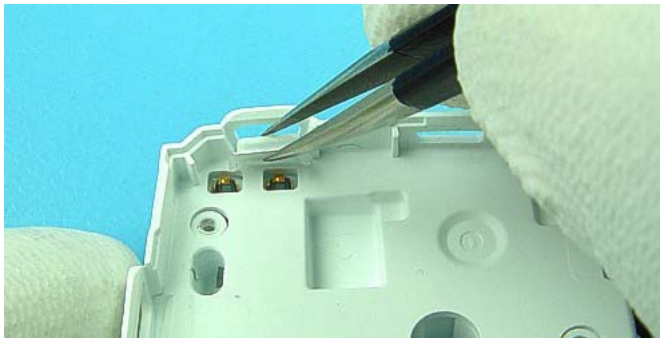
27. Remove Camera Shutter Key.

**27**



28. Remove Power Key.

**28**

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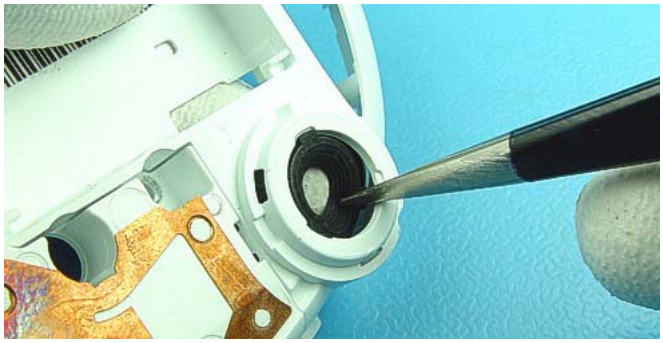
29. Detach Camera Window by placing SRT-6 as shown and pressing upwards forcefully.

**29**

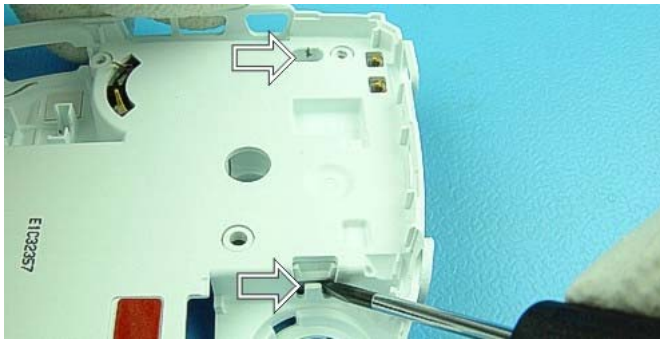
30. Press out Rubber Gasket from the outside.

**30**



31. There are two plastic clips, which have to be unlocked before removing GSM Antenna.

**31**




32. Finally remove HF Speaker with tweezers.

**32**

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# Re-Assembly Instructions

## Assembly of B-Cover Module

1. Assemble the Handsfree Speaker into the GSM antenna housing making sure to apply even pressure around the circumference of the device. Ensure the alignment feature on the device is aligned to the relevant feature in the antenna housing.

**Note:** Ensure the contacts are avoided and the speaker gauze is first fitted to the GSM antenna module.

2. Snap the GSM antenna module onto the B-Cover module ensuring the clip nearest the camera window is engaged first, whilst taking care to ensure the speaker contacts are aligned inside the B-Cover aperture before all clips are assembled to avoid any damage to them.

**Note:** The GSM antenna module will not sit parallel to the B-Cover when it is assembled. There will be a gap next to the speaker - this is normal.

3. Fit the camera window gasket/ boot onto the B-Cover moulding ensuring first that the B-Cover is internal side up so you can see the alignment of the gasket with the three alignment clips into the B-Cover recesses.

**Note:** Ensure that the annulus of the camera boot is concentric with the B-Cover camera annulus.


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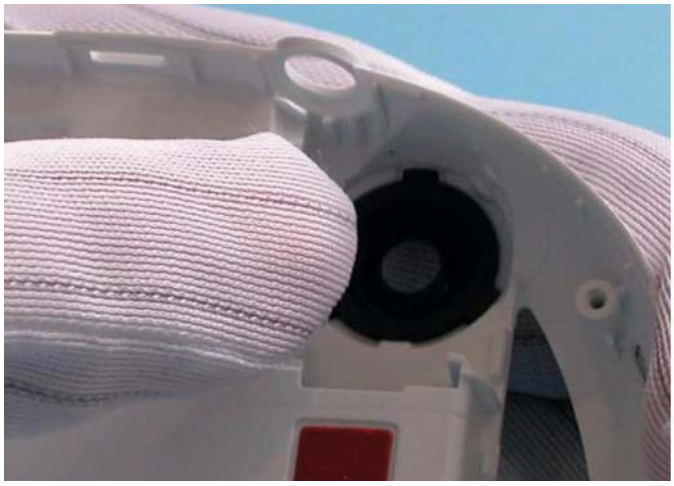

4

4. Turn the B-Cover over once the boot is aligned and push the boot retention clips into the recesses in the B-Cover so they are visible from the outside of the B-Cover.

6

5. Assemble the camera window adhesive to the camera window annulus on the B-Cover, ensuring it is centrally fitted and the yellow backing tape is removed.

6. Align the camera window to the B-Cover using the alignment feature in both the window and the B-Cover. Press down on the edges of the window (taking care not to damage it) until all three clips snap home to the B-Cover.

**Note:** Ensure the B-Cover is supported underneath when the window is assembled. Assembly force must be at least 60N/cm² for at least 6 seconds.

7

7. Take an IR window and snap it into the B-Cover ensuring that it is orientated the correct way around. Assemble the right hand side clip first into the B-Cover then snap the second clip into place.

**Note:** Ensure the front and back of the window is not cosmetically damaged by wearing soft gloves when pressure is applied to the window.


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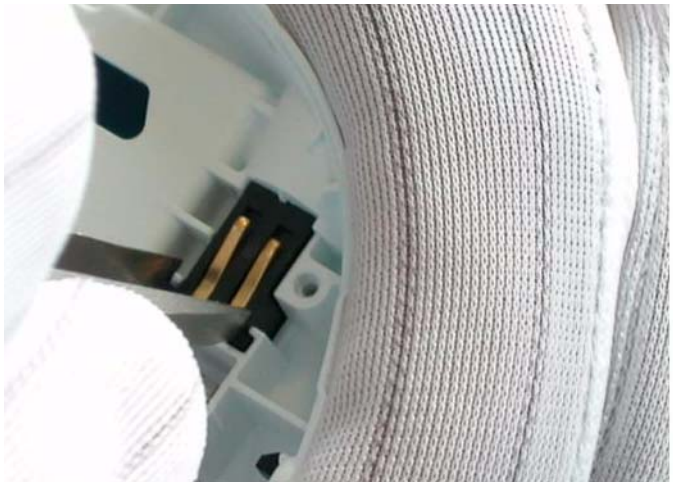
**8**

8. Assemble the WCDMA antenna into the B-Cover module ensuring the antenna is engaged under the clip nearest the battery bay wall before the external clip is made by pushing down on the antenna to clip it to the B-Cover.

**Note:** Ensure the clips are engaged by checking the clip is within the clip aperture of the outside of the B-Cover. Ensure also that the metallization on the antenna is not scratched or contaminated.



**9 (i)**

9. Assemble all electromechanical devices into their specific apertures provided for them in the B-Cover module, including the vibra, microphone and DC Jack. Ensure each device is fully assembled into their individual cavities and in the correct orientation as illustration opposite indicates.

**Note:** Ensure the contacts on each device are avoided and the DC Jack snapped home.

**9 (ii)**

9 (ii). Removing the microphone.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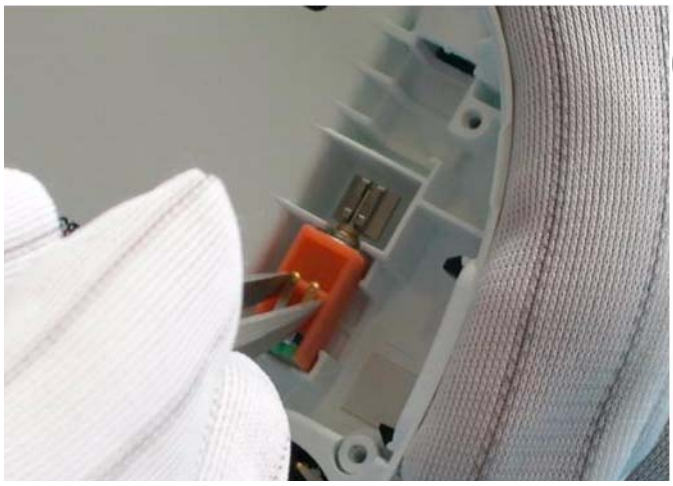

**9 (iii)**

9 (iii). Removing the Vibra Motor.

**10**

10. Ensure each of the three keys is fully assembled into their apertures. Ensure the bottom of the key is aligned into the B-Cover with the face being pushed through the aperture in the B-Cover. The key flanges must be tight up against the B-Cover flange with no gap.

**Note:** Ensure the Class I faces of the keys are not touched or damaged during the assembly sequence.

## Assembly of UI Module

**1**

1. Place the earpiece into the LCD frame, ensuring the alignment feature on the device is aligned with the slot in the frame. Press the device into the frame.

**Note:** Ensure the metal body of the earpiece is not distorted and the contacts are not deformed. Ensure the earpiece is fully assembled into the LCD frame.


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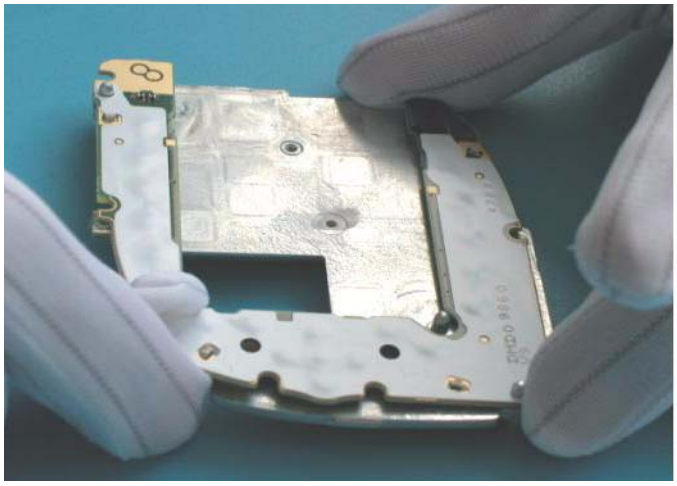
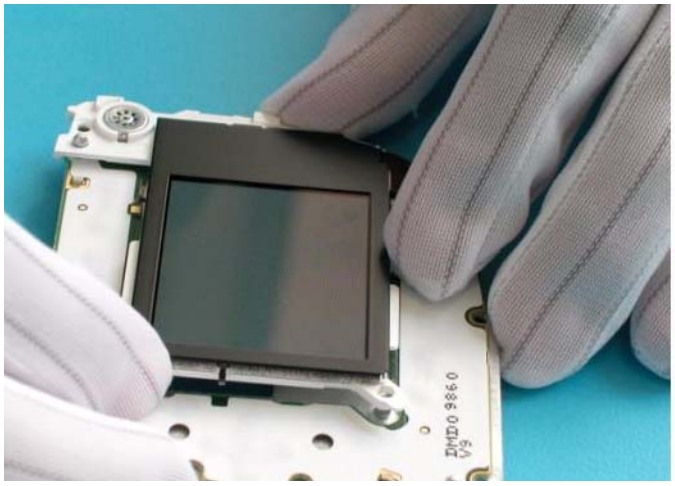


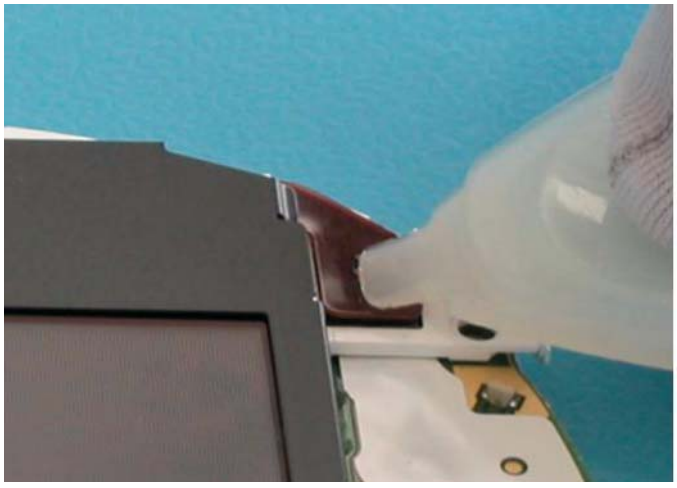
2. Assemble the UI PWB Module onto the Engine shield ensuring the shield is kept flat and not distorted or bent. The PWB must be LED's up and care must be taken not to touch the board to board connector pads.

**Note:** Ensure the datum pins on the shield are not deformed.



3. Assemble the LCD module onto the UI shield assembly, ensuring the clip at the top & middle of the frame near the ear piece is assembled first and then the bottom frame location hole is assembled over the shield pin.

**Note:** Ensure the LCD is kept flat at all times and only ever handled from the sides. The protective tape must be kept on the LCD during handling and assembly.



4. Clip the male LCD connector on the LCD module into the female LCD connector on the UI PWB, ensuring to align the devices first. The connector should snap into place.

**Note:** The connector must be assembled keeping it flat and applying even pressure across the top of the rigidiser.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5

5. Place a Navi key assembly onto the UI PWB, ensuring the alignment pips on the bottom of the Navi key assembly are located into the holes in the UI PWB.

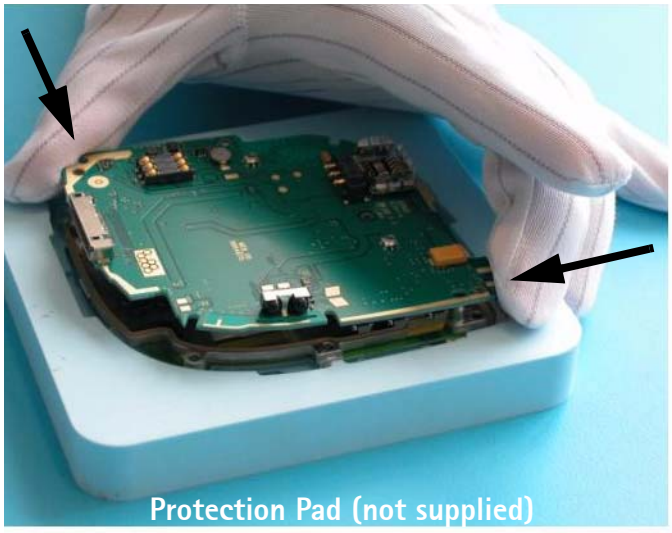
**Note:** Ensure the Class I surfaces of the Navi key are kept clean and undamaged. These must be checked before assembly.

6

6. Place a lightguide assembly onto the UI module assembly, sliding the top right lightguide tab under the LCD frame first, then clipping the right then left clips to the engine shield and finally placing the top left lightguide alignment hole over the top left engine shield alignment pin.

**Note:** Ensure the lightguide is not distorted and the side clips are fully assembled and not cracked. Also ensure that all LED's are within the recesses in the lightguide provided for them.

## Assembly of ATO Module




1. Assemble the engine PWB onto the UI module (making sure the module is first placed LCD down). Ensure the engine is located onto the engine shield alignment pins.

**Note:** Ensure the board to board connector and camera assembly are avoided by only holding the PWB module in the designated areas indicated.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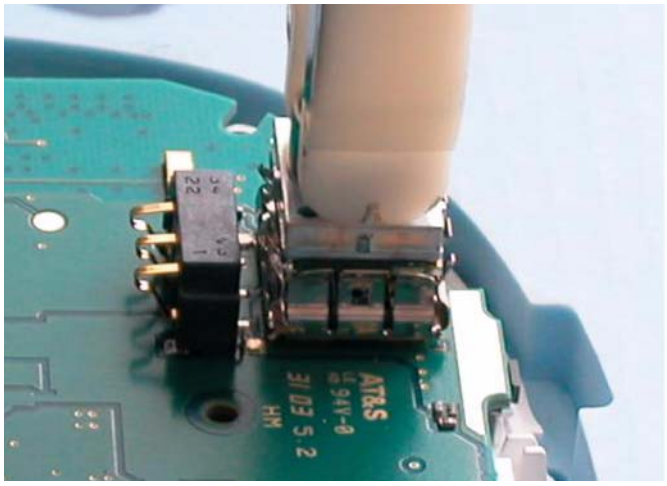

2

2. Assemble the camera into the camera connector using the SRT-11 Camera Assembly tool.

**Note:** Ensure the alignment pip on the SRT-11 Camera Assembly tool is aligned with the pip on the camera which is in turn aligned with the dot on the camera connector assembly before location and assembly. Also ensure that the camera has all three clips connected to the shield.

3

3. Assemble the B-Cover module onto the UI & PWB modules. Locate the top of the phone first to avoid damage to the camera and camera shield and so the two alignment pins on the engine shield find their location holes in the B-Cover.

**Note:** Ensure the alignment of the B-Cover module is correct by aligning it gently before the clipping of the two modules. Take extra care as this is a blind assembly.

4

4. Clip all three UI module to B-Cover module clips together ensuring the top clip is made first followed by the clip by the system connector and then finally the clip on the side.

**Note:** Ensure pressure is only applied directly above the clips.


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**5** 5. Assemble the 7th screw into the back of the B-Cover making sure not to damage the B-Cover. This screw must be a new 5.3mm x 1.6mm T6 (IP6) machine screw (NMP 6150905) with an orange threadlock patch applied with a torque of 26 Ncm.

**Note:** Only use a hand torque driver.

**6** 6. Assemble the 6 screws into the ATO in the order indicated opposite. Using new 9.0mm x 1.6mm T6 Rem-form screws (NMP 6150903). A torque of 19 Ncm must be applied to these screws when an old B-cover is re-used and 22 Ncm for a new cover.

Ensure the screws heads are sitting flush on the lightguide or LCD frame.

**Note:** Only use a hand torque driver.

## Assembly of Transceiver

**1** 1. Assemble the A-Cover module onto the ATO module using the clipping sequence outlined opposite, ensuring clip number one is slid onto the lightguide clip (pressure must only be applied to the edge of the A-Cover over the clips and **NOT** over the LCD).

**Note 1:** Each of the clips must be checked for correct assembly in which case the clip must be fully visible within the A-Cover aperture. Make sure the blind clip over the system connector (9) is also assembled.

**Note 2:** Make sure the LCD protective tape is removed before assembly of A-Cover module.


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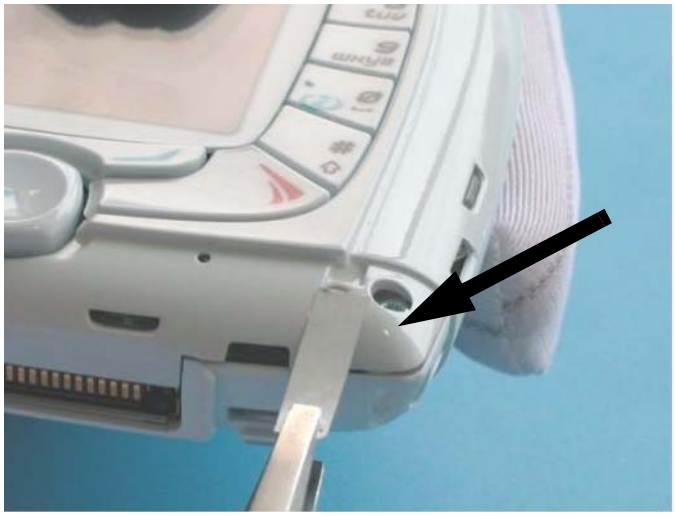


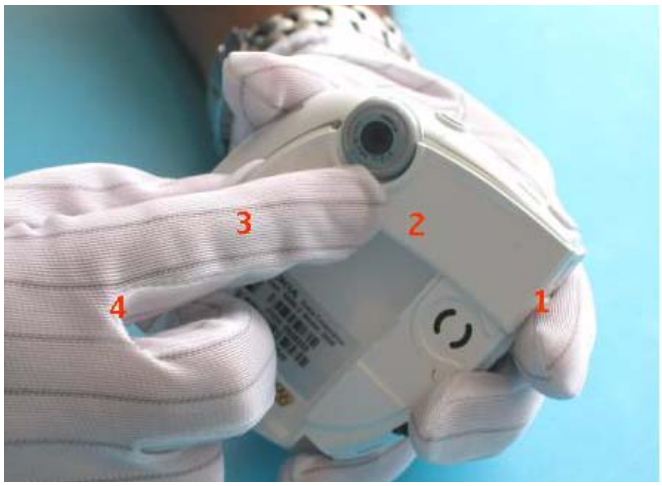
**2**

2. **APAC ONLY** - The tamper proof label must be fitted across the split line of the A-Cover and B-Cover in the place indicated in the illustration opposite.

**3**

3. Assemble the corner piece onto the ATO module ensuring the top side is placed in its retention recess within the A-Cover first. Pushing the corner piece downwards snaps the bottom clip home.

**Note:** Be sure to only apply pressure to the corner piece and that the component is the correct way around.




**4**

4. Assemble the D-Cover module to the ATO module by firstly removing the protective tape from the adhesive at the back of the D-Cover and then clipping the D-Cover clips to the ATO in order shown opposite.

**Note:** Apply light pressure across the D-Cover once assembled to ensure the adhesive takes. Ensure gloves are used and the cosmetic Class I painted surface of the D-Cover is not damaged or contaminated in any way.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# Visual Quality Checks during Re-assembly

- Ensure the window in the A-Cover module has no contamination, scratches or wear in the viewing area of any kind
- Ensure the camera window viewing area is clear of contaminants or defects
- Ensure the corner piece is correctly fitted and free from contaminants or defects
- Ensure the side keys all depress
- Ensure all 7 screws are fitted and fully assembled
- Ensure the keymat and navi key are free from contaminants or defects
- Ensure the C and D-Covers as well as the painted surface on the A-Cover are free from contaminants or defects
- Ensure all nine A-Cover clips are fully assembled
- Ensure the window border colour is the same colour as the A-Cover
- Ensure the window has protective tape fitted
- Ensure the camera window has protective tape fitted
- Ensure none of the A-Cover clips are broken
- Ensure all three UI module to B-Cover module clips are made
- Ensure there is no contamination or damage in the B-Cover battery bay area
- Ensure the LCD protective tape and D-Cover adhesive backing tapes have been removed
- Ensure the phone is free from dust or hairs


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